

Date: Thursday, 10/04/2008 10:37:06 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CABIN FLOOR PROTECTOR
Job Number : 38518	
Estimate Number : 12970	
P.O. Number :	Part Number : D35746
This Issue : 10/04/2008 S.O. No. :	Drawing Number : D3574 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : 10/04/2008 Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 35948	Material :
Written By :	Due Date : 18/04/2008 Qty: 2 Um: Each
Checked & Approved By : <u>JD 08.4.10</u>	
Comment : Est Rev :A New Issue 07.07.23 EC verified by:JLM	

Additional Product

Job Number:



Seq. #: **Machine Or Operation:** **Description :**

1.0 F60029- MLEXS12576002904 lexan grey



Comment: Qty.: 32.0000 sf(s)/Unit Total : 64.0000 sf(s)
 F60029 lexan sheet
 Batch: 103106 HB 8-4-11

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3574
 Dwg Rev: A
 Prog Rev: A

HB 8-4-11

(2)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB 8-4-11

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

08/04/14 (x2)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

SAD 08/04/13

(2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/04/2008 10:37:06 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 38518

Part Number: D35746

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JS 08/04/14 (X2)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock
Location: _____

JS 08/04/16 (X2)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/17 JS

Job Completion



mf 08-04-16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

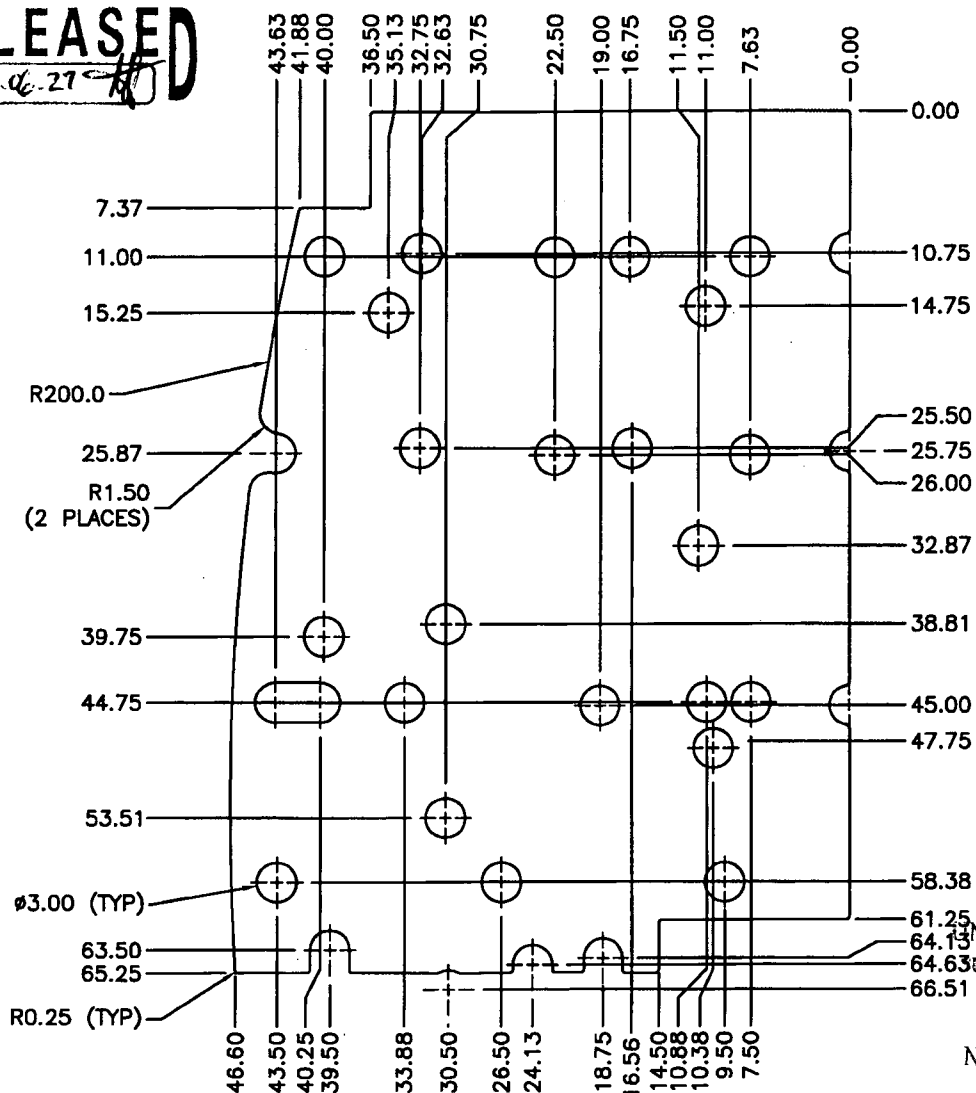
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN LE	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED H	DRAWING NO. D3574	REV. A SHEET 1 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14
A	07.06.08	NEW ISSUE	

RELEASED
07-06-27



D3574-1 CABIN FLOOR PROTECTOR (SHOWN). D3574-2 (OPPOSITE)

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8961

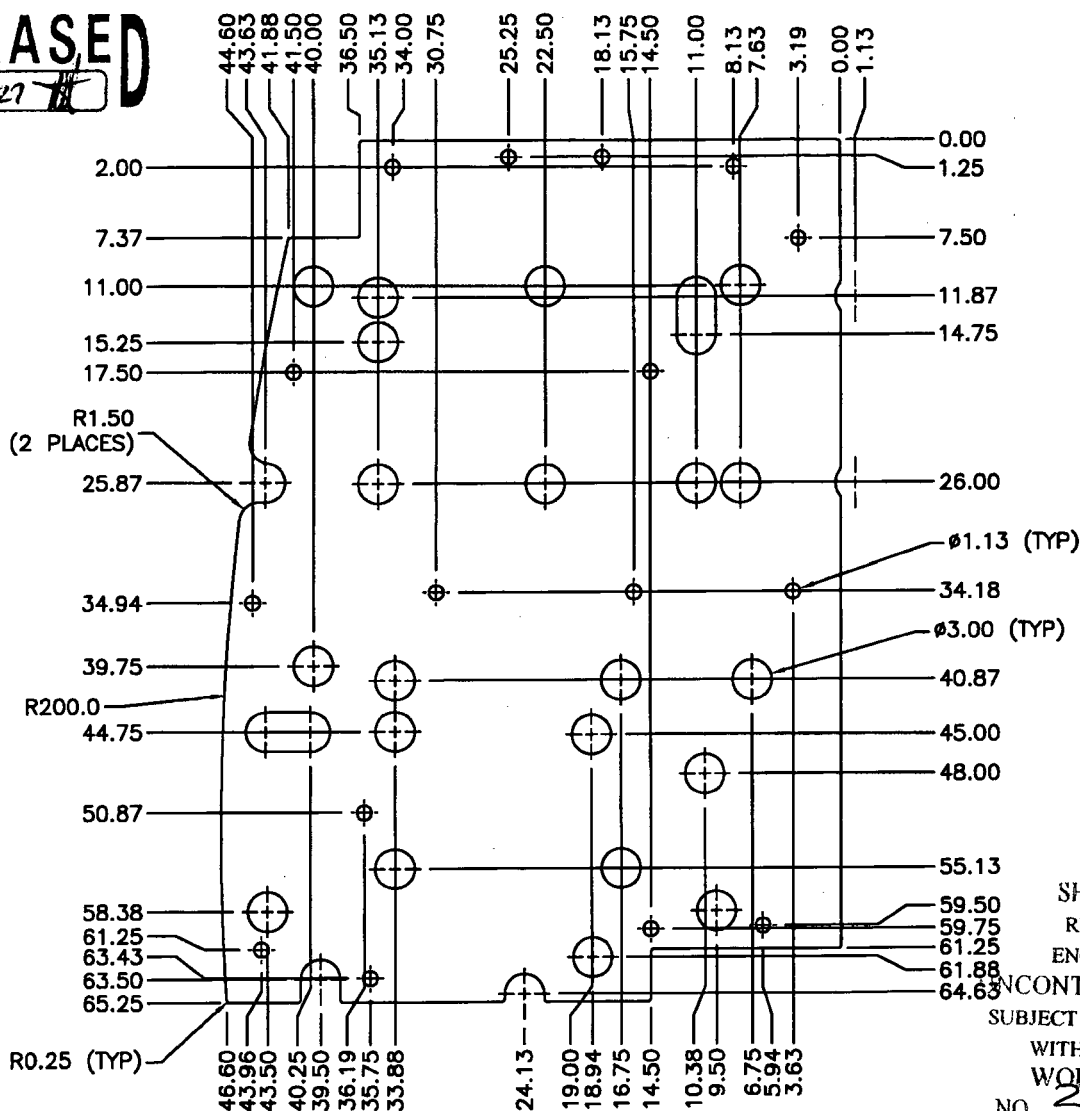
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DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

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07.06.27



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NO. 38518

D3574-3 CABIN FLOOR PROTECTOR

NOTES:

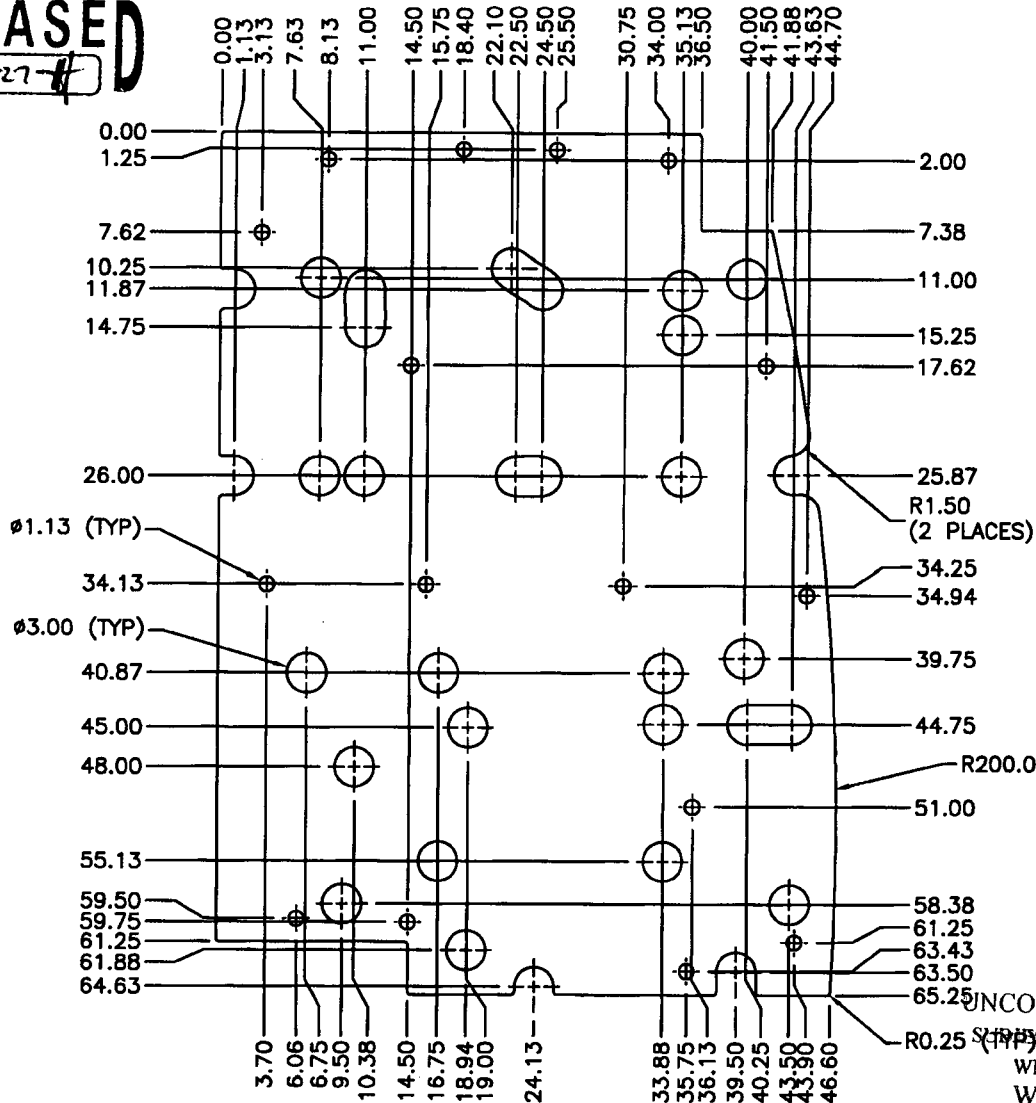
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8962

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DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE 1:14

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NO. 38578

D3574-4 CABIN FLOOR PROTECTOR**NOTES:**

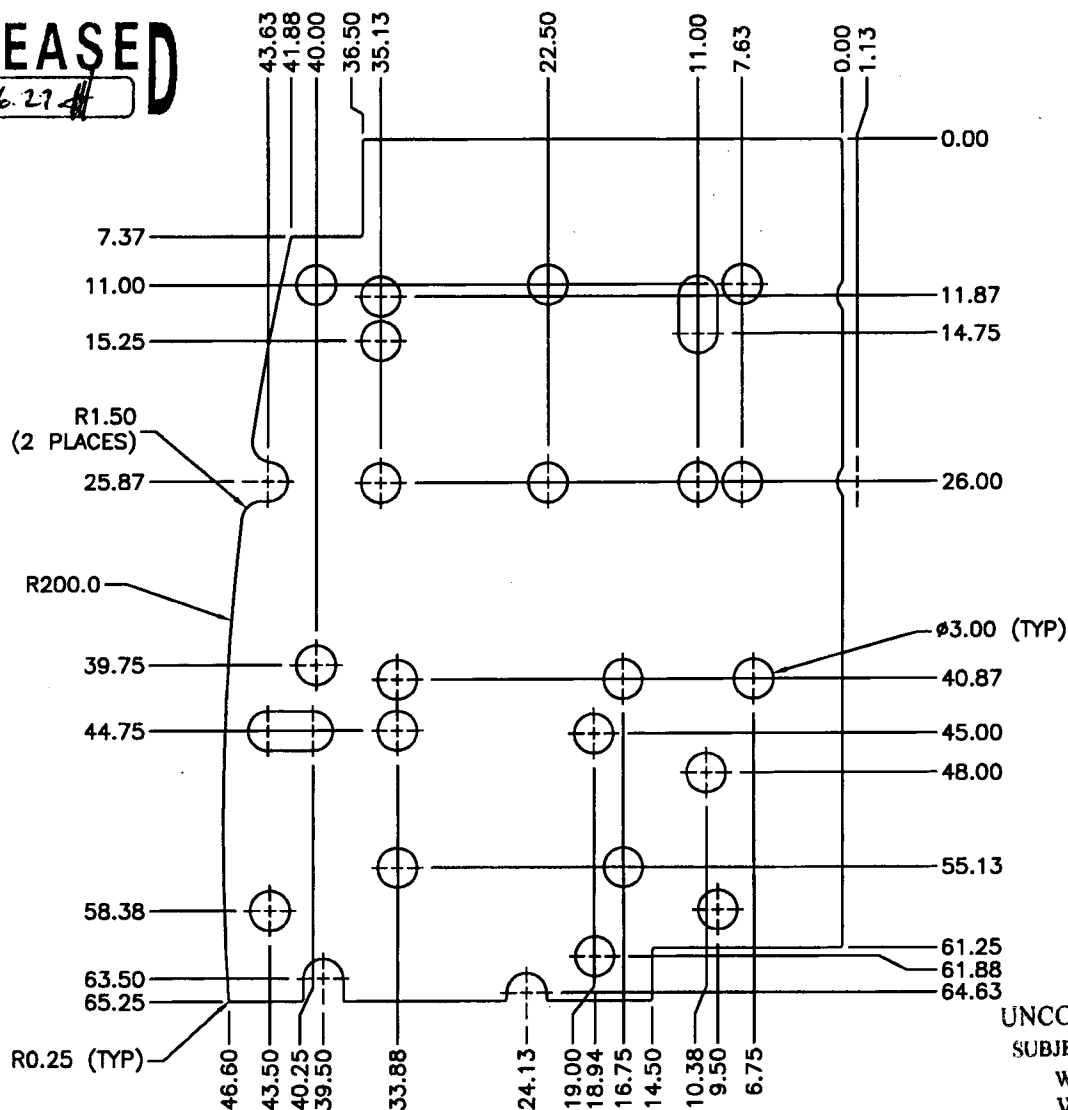
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8963

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DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
07.06.27**D3574-5 CABIN FLOOR PROTECTOR****NOTES:**


- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-5" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8964

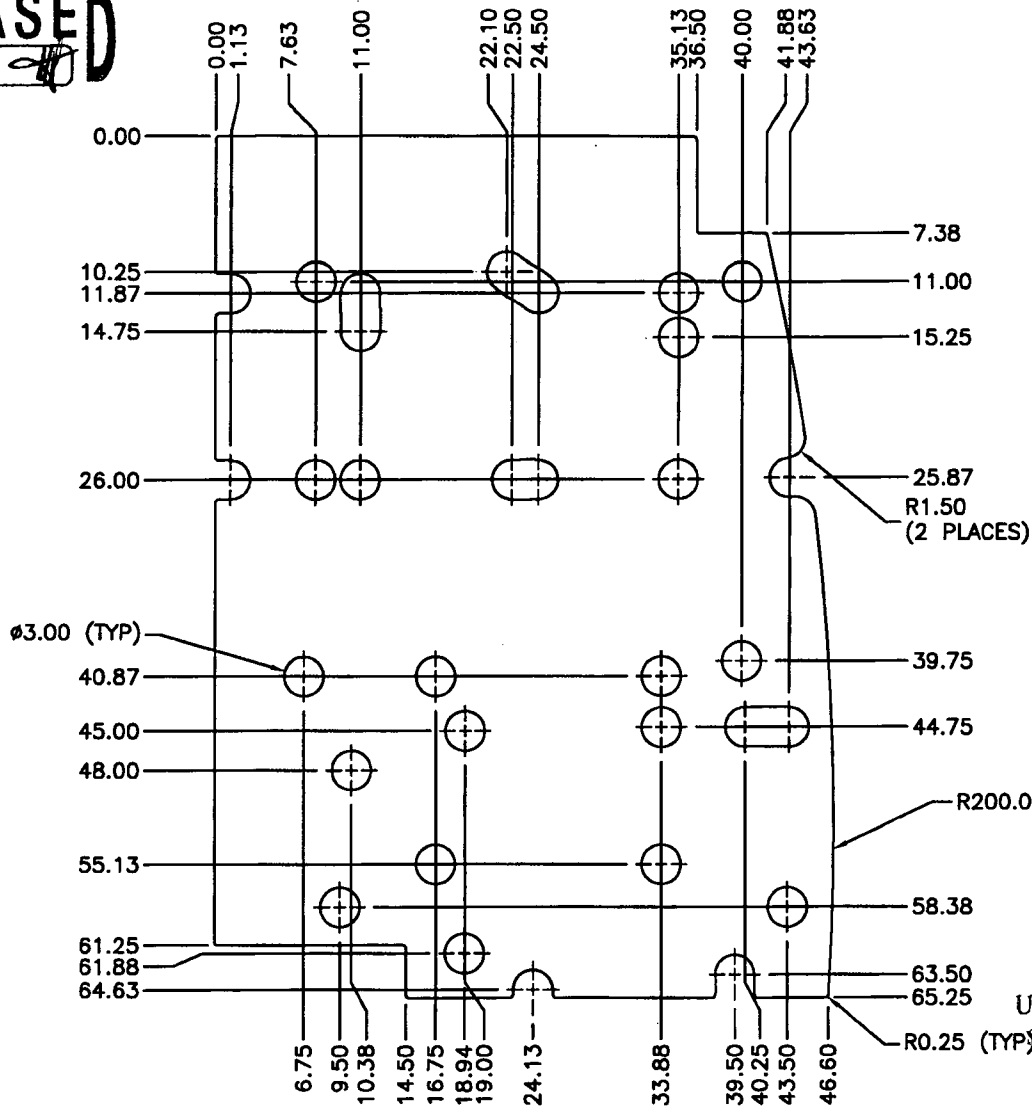

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DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

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07.06.27 

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NO. **38518**

D3574-6 CABIN FLOOR PROTECTOR**NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8965

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DART AEROSPACE LTD		Work Order: 38518
Description: CABIN FLOOR PROTECTOR		Part Number: D3574-6
Inspection Dwg: D3574-6 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 3.00	+ .012 - .001	3.001	*			
7.37	+/- .030	7.37	*			
11.00	+/- .030	11.00	*			
15.25	+/- .030	15.25	*			
39.75	+/- .030	39.75	*			
44.75	+/- .030	44.75	*			
58.38	+/- .030	58.38	*			
63.50	+/- .030	63.50	*			
65.25	+/- .030	65.25	*			
11.87	+/- .030	11.87	*			
14.75	+/- .030	14.75	*			
26.00	+/- .030	26.00	*			
40.87	+/- .030	40.87	*			
45.00	+/- .030	45.06	*			
48.06	+/- .030	48.06	*			
55.13	+/- .030	55.13	*			
61.25	+/- .030	61.25	*			
61.88	+/- .030	61.88	*			

Measured by: LB	Audited by: S	Prototype Approval: 1/
Date: 8-4-11	Date: 08/04/14	Date: 1/

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order:	38518
Description: CABIN FLOOR PROTECTOR		Part Number:	D 3574-6
Inspection Dwg: D3574-6 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.63	+/- .030	7.63	X			
11.00	+/- .030	11.00	F			
22.50	+/- .030	22.50	X			
35.13	+/- .030	35.13	X			
36.50	+/- .030	36.50	X			
40.00	+/- .030	40.00	X			
41.88	+/- .030	41.88	X			
6.75	+/- .030	6.75	X			
9.50	+/- .030	9.50	X			
10.38	+/- .030	10.38	X			
14.50	+/- .030	14.50	X			
16.75	+/- .030	16.75	X			
18.94	+/- .030	18.94	X			
19.00	+/- .030	19.00	X			
24.13	+/- .030	24.13	X			
33.88	+/- .030	33.88	X			
39.50	+/- .030	39.50	X			
40.25	+/- .030	40.25	X			
43.50	+/- .030	43.50	X			
46.66	+/- .030	46.66	X			

Measured by: HB	Audited by: S	Prototype Approval: N/A
Date: 8-4-11	Date: 08/01/14	Date: 8

Rev A	Date	Change New Issue	Revised by KJ/JLM	Approved
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